

# Work Order ID 78883

January-17-12 7:24:49 AM

*Now*

**\*78883\***

Page 1

Item ID: D4014-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Guage Cover

Start Date: 1/16/12

Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/16/12

Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4014

B

100

0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

*6061 . 063*

Memo

1-Cut as per Dwg

Dwg Rev: *62*

Prog Rev: *13*

2-Deburr if necessary

0.00

*B12-1-17*

*(9)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

Memo

0.00

*B12-1-17*

**Work Order ID 78883****\*78883\***

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Item ID: D4014-3

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Guage Cover

Start Date: 1/16/12 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 1/16/12 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

**\*130\***

Small Fab

Memo

Small Fab

form as per dwg using DT9589

0.00

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

Quality Control

0.00

Handwritten signature and date: 12/01/18

Handwritten note: 5 12/01/17

Handwritten circled number: 49

Handwritten note: 5 12/01/18

# Work Order ID 78883

**\*78883\***

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January-17-12 7:24:49 AM

Item ID: D4014-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Gauge Cover

Start Date: 1/16/12

Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/16/12

Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

*9X of M-12/01/18*

151

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

**\*151\***

Powdercoat

Powder Coating

Memo

Start Time:

Oven Temperature:

Finish Time:

0.00

*10-40  
3200 F  
11-10*

*9X of M-12/04/18*

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Quality Control

Memo

0.00

*9X of M-12/01/18  
COUNTED*

*M115128*

# Work Order ID 78883

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**\*78883\***

Page 4

Item ID: D4014-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Guage Cover

Start Date: 1/16/12

Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/16/12

Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location: St

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

*Handwritten signature and date 12/01/19 with a circled 'P'.*

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

*Handwritten date 12/1/19 and signature.*

*Handwritten date 12-01-17 and a circled 'P'.*

# Picklist Print

January-17-12 7:24:49 AM

Page 1

Work Order ID: 78883

Parent Item: D4014-3

Parent Item Name: Guage Cover

Start Date: 1/16/12

Required Date: 1/16/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.28 new issue Prelim EC verified by: DD IPP Rev:B 10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	354.0696	0.007	0.0294737		12-1-17.5	

Location

Loc Qty

Loc Code

MAT021

354.0695684

113608

0

116308

11.9555684

117285

75.414

119331

49.2

119802

25.5

120218

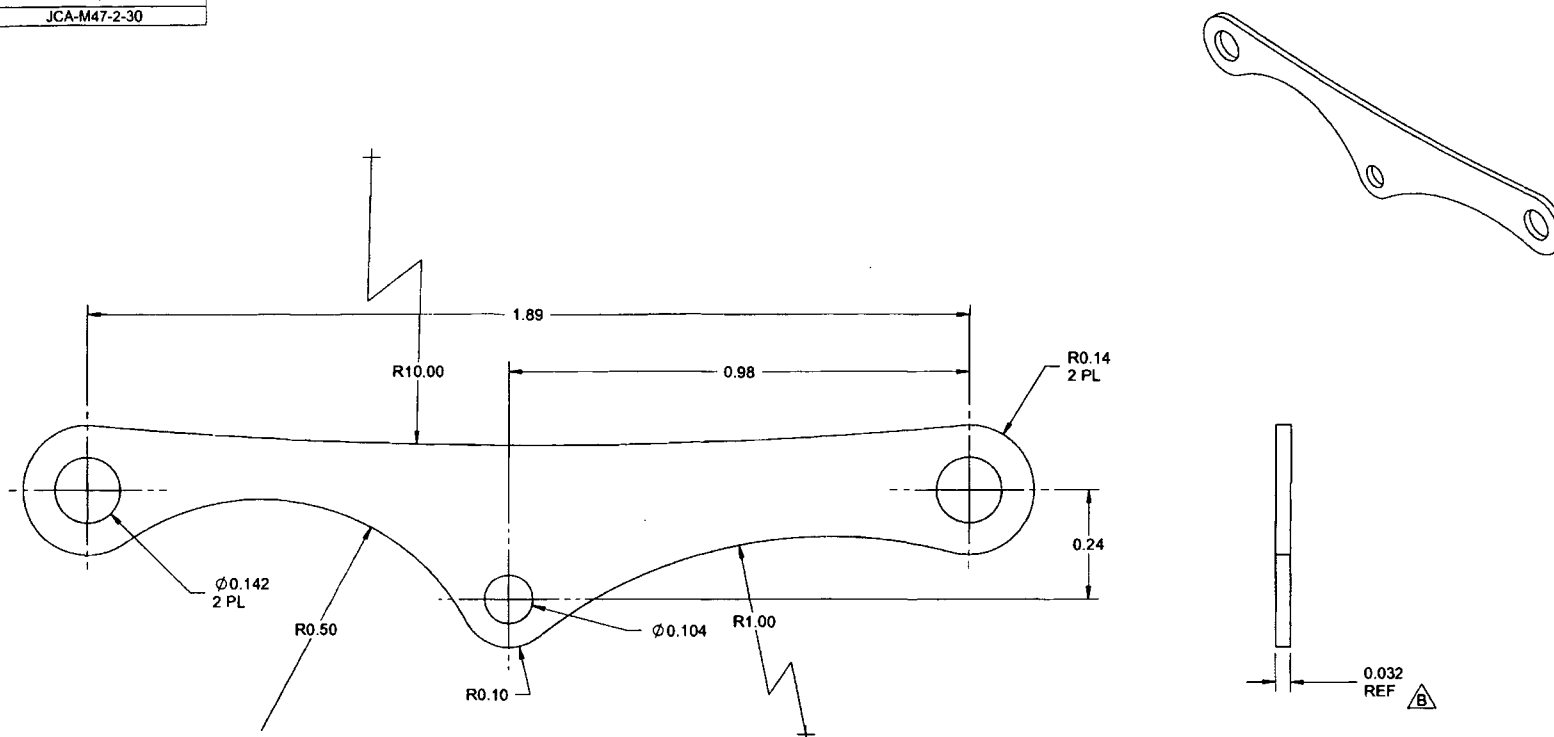
192

116308

9



DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4014-1	JCA-M47-2-30



**D4014-1 SWITCH PLATE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK  $\triangle B$   
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.025
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

B	REVISE MATERIAL THICKNESS		10.11.18	
A	NEW ISSUE	HS	10.03.11	
REV.	DESCRIPTION	BY	DATE	
DESIGN	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN				
CHECKED				
MFG. APPR.		D4014	REV. 1 OF	
APPROVED		TITLE	SCALE	
DE APPR.		COVER	NTS	
DATE		10.11.18		
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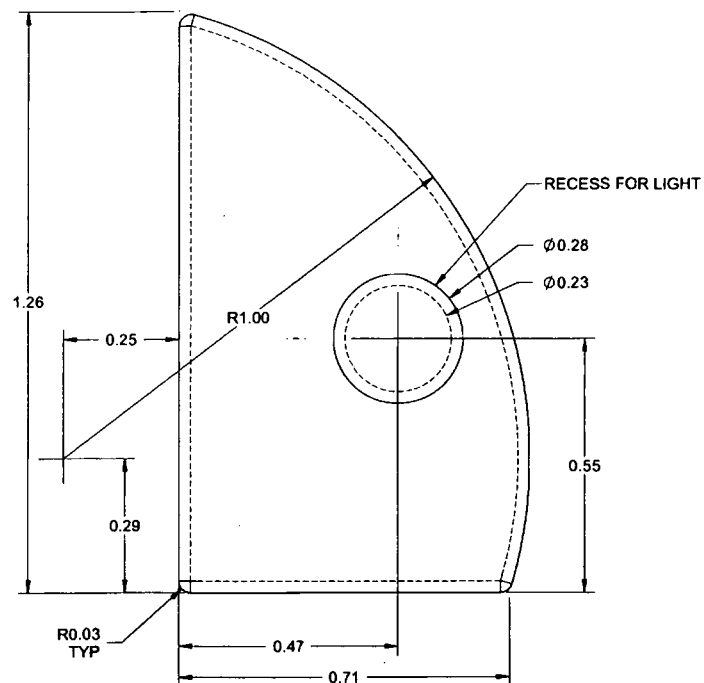
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4014** REV. B  
TITLE **COVER** SCALE NTS

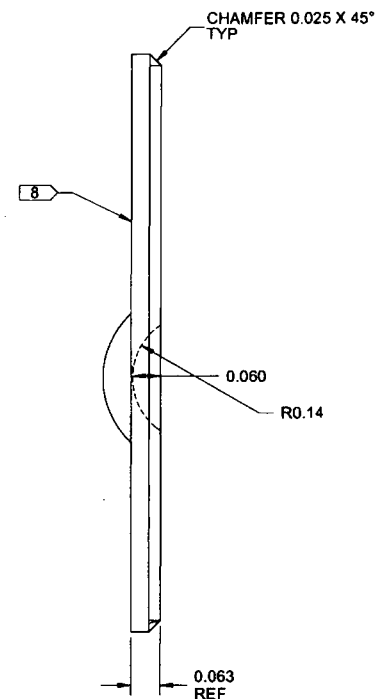
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**RELEASED**  
2011-05-30

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4014-3	JCA-M47-2-31



**D4014-3 GAUGE COVER**



**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs
- 8) POWDER COAT THIS SIDE ONLY

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4014</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>COVER</b>	NTS
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2011-05-30  
JMC